



DAPHNE PLASTIC QUENCH HF

1. Application

Daphne Plastic Quench HF is a water-soluble quenching oil used for induction hardening.

2. Characteristics

1. Superior crack ability prevention because of its relatively small quenching speed below 250 °C.
2. Superior anti-bacteria property shows less deterioration especially at summer period.

3. Typical Specification

<u>Soluble Concentration</u>		<u>Undiluted Solution</u>	<u>5%</u>	<u>10%</u>	<u>20%</u>
Viscosity	@ 40 °C cSt	29.5	0.873	1.129	1.809
Refractive Index	N_D^{20}	1.3714	1.3348	1.3369	1.3406
pH		10.2	9.3	9.4	9.8

4. Properly Using

1. Optimum temperature is 30-40°C if heat up over 65°C polymer component will be separated.
2. Selection of Soluble concentration according to quenching speed and use hand-refractrometer to measure concentration.
3. Incase of using at high concentration, polymer compounds possible adhere on surface of material, it should be washed by hot water.

5. Concentrate Application

High Frequency Hardening

(1) Carbon Steel	Rear Axle Shaft	5%	Gear Type	5~8%
	Clank Shaft	5%		
	Cam Shaft	5%		
(2) Low Alloy Construction Steel	Rear Axle Shaft	5~10%	Gear Type	8~10%
	(3) Main Blue Cast Iron	Boil Hub		